

Date: Tuesday, 04/07/2006 12:36:11 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DECK PLATE,FWD ,350 LITTER KIT
Job Number	: 27737	Part Number	: D2364
Estimate Number	: 11104	Drawing Number	: D2364 REV.F
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 04/07/2006	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Revision	: F
First Issue	: 28/06/2006	Type	: MACHINED PARTS
Previous Run	:	Material	: N/A
Written By	: <u>See Comment Below</u>		
Checked & Approved By	:		
Comment	: EST. REV. E 00.06.26 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
		 Comment: Qty.: 0.6792 sf(s)/Unit Total : 5.4340 sf(s) 2024-T3 .063 Aluminum sheet (M2024T3S063) Batch: <u>M101022</u>
2.0	WATER JET	 Comment: FLOW WATER JET
3.0	QC2	 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	 Comment: SECOND CHECK
5.0	SMALL FAB 1	 Comment: SMALL & MEDIUM FAB RESOURCE 1
6.0	POWDER COATING	 Comment: POWDER COATING / Acid etch & Alodine . Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Date: Tuesday, 04/07/2006 12:36:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 27737

Part Number: D2364

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LB 06/08/01 (8)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST173

LB 06/08/01 (8)

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/08/02 (8)

Job Completion



LB 06/08/01

Date: Wednesday, 6/28/2006 4:17:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DECK PLATE,FWD ,350 LITTER KIT		
Job Number	: 27737					
Estimate Number	: 11104					
P.O. Number	:			Part Number	: D2364	
This Issue	: 6/28/2006	S.O. No.	:	Drawing Number	: D2364 REV.F	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /	Type	: MACHINED PARTS	Drawing Revision	: F	
Previous Run	:			Material	:	
Written By	:			Due Date	: 7/22/2006	
Checked & Approved By	: <u>df</u> 06 06 29			Qty:	8 Um: Each	
Comment	: EST. REV. E 00.06.26 Removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 0.6792 sf(s)/Unit Total : 5.4340 sf(s) 2024-T3 .063 Aluminum sheet (M2024T3S063) Batch: M101022	<u>W</u> 08 07 11 (8)
2.0	SHEAR		
		Comment: SHEAR Cut blanks: 13.70" x 6.80" +0.015/-0.000	
3.0	HAAS Water Jet	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine D2364 as per Folio D2364 and Dwg D2364	<u>W</u> 08 07 11 (8)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:17:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 27737

Part Number: D2364

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/09/02

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	27737
Description: Litter Deck Plate Kit (350)	Part Number:	D2364
Inspection Dwg: D2364 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

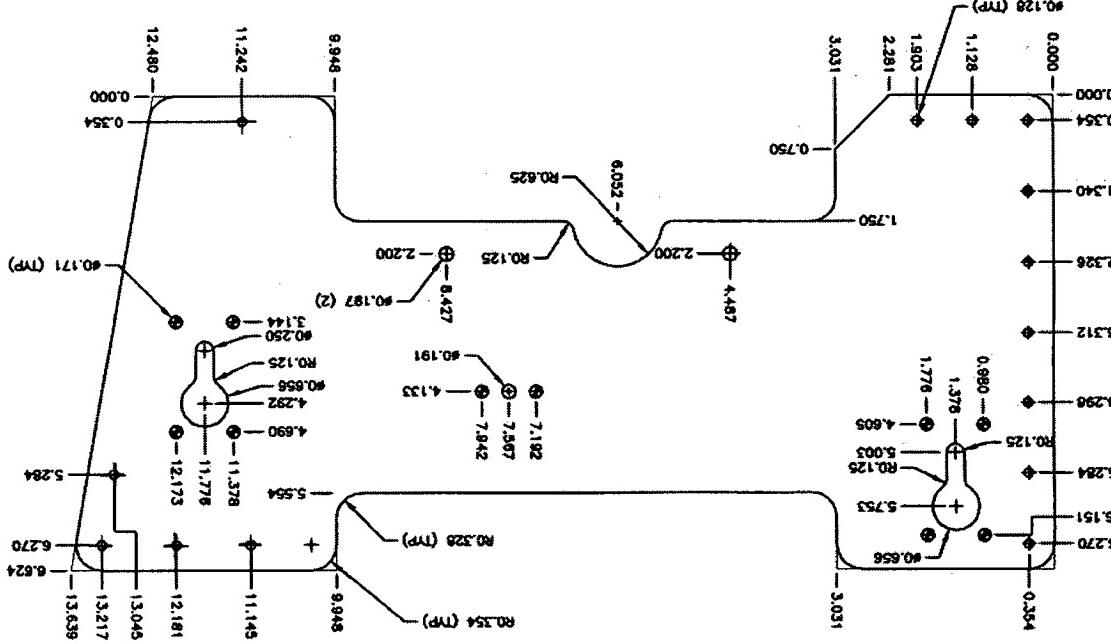
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.625	✓		VERN	
Ø0.171	+0.005/-0.000	0.171	✓		VERN	
0.354	+/-0.010	0.356	✓		VERN	
11.242	+/-0.010	11.245	✓		Hight Gauge	
3.031	+/-0.010	3.031	✓		VERN	
1.903	+/-0.010	1.906	✓		VERN	
1.128	+/-0.010	1.130	✓		VERN	
0.354	+/-0.010	0.353	✓		VERN	
1.340	+/-0.005	1.343	✓		VERN	
2.326	+/-0.010	2.327	✓		VERN	
3.312	+/-0.010	3.313	✓		VERN	
4.298	+/-0.010	4.299	✓		VERN	
5.284	+/-0.010	5.284	✓		VERN	
6.151	+/-0.010	6.151	✓		VERN	
6.270	+/-0.010	6.270	✓		VERN	
0.354	+/-0.010	0.356	✓		VERN	
3.031	+/-0.010	3.031	✓		VERN	
Ø0.656	+0.005/-0.000	0.656	✓		VERN	
5.003	+/-0.010	5.003	✓		VERN	
4.605	+/-0.010	4.607	✓		VERN	
1.776	+/-0.010	1.779	✓		VERN	
0.980	+/-0.010	0.978	✓		VERA	
4.487	+/-0.010	4.492	✓		VERN	
7.192	+/-0.010	7.198	✓		VERN	
7.597	+/-0.010	7.573	✓		VERN	
7.942	+/-0.010	7.948	✓		VERN	
Ø0.191	+0.005/-0.000	0.191	✓		VERN	
Ø0.197	+0.005/-0.000	0.197	✓		VERN	
11.145	+/-0.010	11.149	✓		VERN	
12.181	+/-0.010	12.183	✓		Hight Gauge	
11.378	+/-0.010	11.375	✓		Hight Gauge	
11.776	+/-0.010	11.780	✓		Hight Gauge	
12.173	+/-0.010	12.176	✓		Hight Gauge	
4.690	+/-0.010	4.693	✓		Hight Gauge	
0.250	+0.005/-0.000	0.250	✓		VERN	
Ø1413.144	+/-0.010	3.151	✓		VERN	
0.171	+0.005/-0.000	0.171	✓		VERN	

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06/07/20	Date:	06/07/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	

DRAWN BY <i>KF</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DESIGN <i>KF</i>	APPROVED <i>KF</i>	DRAWING NO. D2364	REV. F SHEET 1 OF 1
CHECKED <i>JM</i>	DATE 98.06.19	TITLE LITTER DECK PLATE, 350	SCALE 2:5
		A 95.01.14 NEW ISSUE	
		B 95.02.09 MOVED KEYWAY	
		D 95.03.06 0.191 WAS 0.197	
		E 95.10.06 GEOMETRY CHANGES	
		F 98.06.19 0.063-0.071 THICK WAS 0.071 (TSR A371)	
 RELEASED <i>98/06/22 KF</i>			

COUNTER SINK HOLES: C_SINK #0.225 x 100. (UPDATED FROM #0.308 x 100.)



NO 27737
WORK ORDER
WITHOUT NOTICE
AMENDMENT
SUBJECT TO AMENDMENT
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

Copyright 1995 by DART AEROSPACE LTD